

Date: Tuesday, 19/08/2008 4:05:26 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CABIN FLOOR PROTECTOR  
 Job Number : 41470  
 Estimate Number : 12663  
 P.O. Number :  
 This Issue : 19/08/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL /MED FAB  
 Previous Run : 40650  
 Part Number : D35751  
 Drawing Number : D3575 REV.A  
 Project Number : N/A  
 Drawing Revision : A  
 Material :  
 Due Date : 05/09/2008 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By : JUD 08.8.19  
 Comment : Est Rev :A New Issue 07-01-22 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MLEXS125F6002904 GE PLASTICS LEXAN SHEET



Comment: Qty.: 11.1993 sf(s)/Unit Total : 44.7972 sf(s)

lexan sheet

Batch: 109455 AB 8-10-1

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3575

Dwg Rev: AProg Rev: AAB 8-10-1

(4)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

AB 8-10-1

(4)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



MM / 08.10.01 (4)

(PTC)

Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

MM 08 10 01 SAD 08/10/05 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3575-1 PAR #: N/A Fault Category: Prod / Prod Assy mat + small NCR: Yes No DQA: D Date: 08/10/01  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 08/10/01

NCR: <u>41470</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-10-01	2.0	1 part scrap. Part is shifted by 0.125" at the holes v. top edges. f.c: operator left the machine running while putting away material, water below shifted material.	<u>AS/142</u>	Scrap & replace Qty 1 M <u>109455</u>	<u>B</u> 8-10-2	<u>AS/142</u>	<u>AS/142</u>	<u>08-10-01</u>

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:05:26 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 41470

Part Number: D35751

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/06 (initials)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: PP Slide

3rd

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/08 (initials)

Job Completion



MF 08-10-08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41470
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b> D3575-1
<b>Inspection Dwg:</b> D3575	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

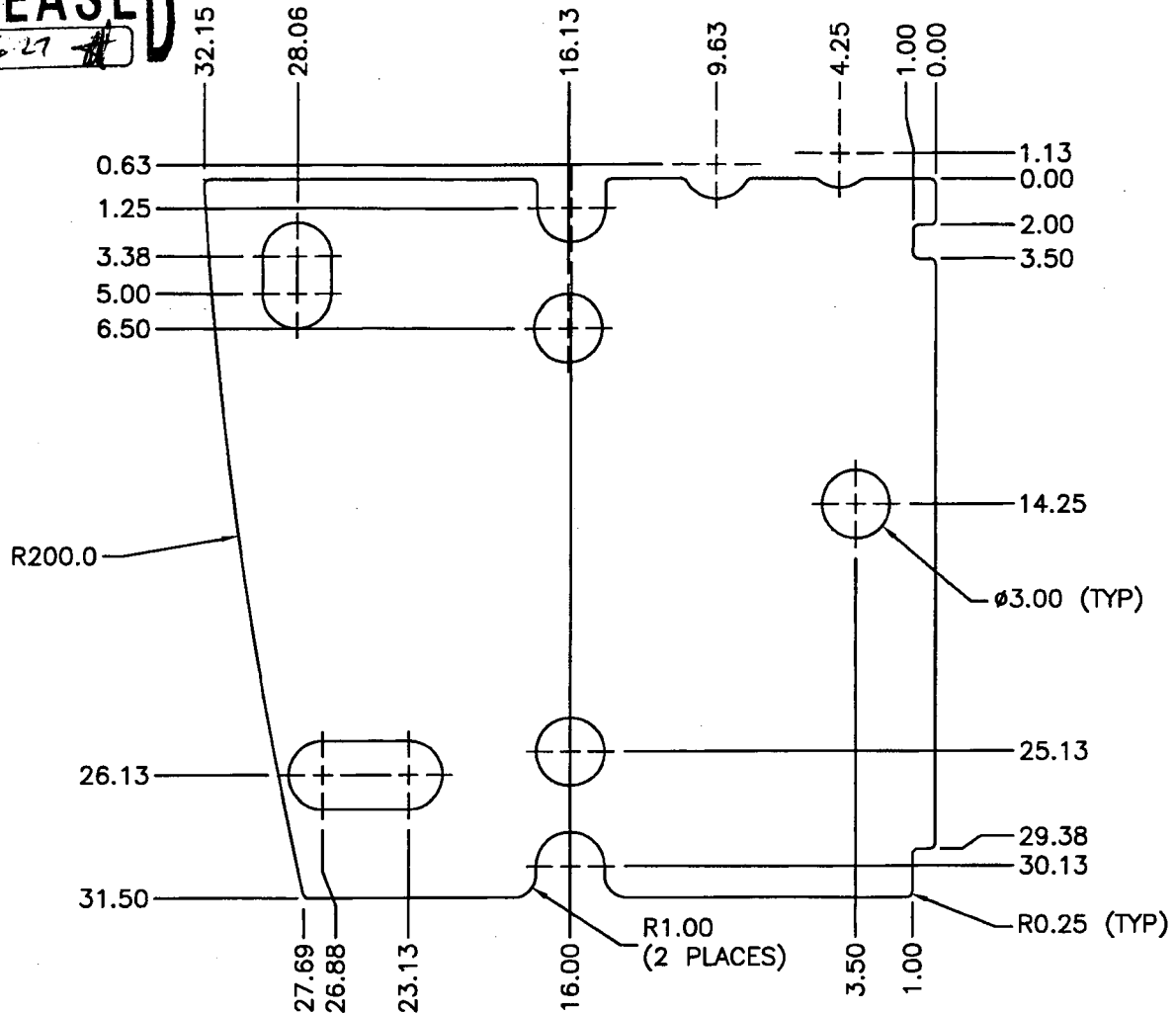
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.005	X			
1.00	+/-0.030	1.00	X			
3.50	+/-0.030	3.50	X			
16.00	+/-0.030	16.00	X			
23.13	+/-0.030	23.13	X			
26.88	+/-0.030	26.88	X			
27.69	+/-0.030	27.69	X			
4.25	+/-0.030	4.25	X			
9.63	+/-0.030	9.63	X			
16.13	+/-0.030	16.13	X			
28.06	+/-0.030	28.06	X			
32.15	+/-0.030	32.15	X			
2.00	+/-0.030	2.00	X			
3.50	+/-0.030	3.50	X			
14.25	+/-0.030	14.25	X			
25.13	+/-0.030	25.13	X			
29.38	+/-0.030	29.38	X			
30.13	+/-0.030	30.13	X			
1.25	+/-0.030	1.25	X			
3.38	+/-0.030	3.38	X			
5.00	+/-0.030	5.00	X			
6.50	+/-0.030	6.50	X			
26.13	+/-0.030	26.13	X			
31.50	+/-0.030	31.50	X			

<b>Measured by:</b> LB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-10-01	<b>Date:</b> 06-10-01	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/DD [Signature]	[Signature]

**DART**

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>#</i>	DRAWING NO. D3575	REV. A SHEET 1 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8
A	07.06.08	NEW ISSUE	

**RELEASED**  
07.06.08

**D3575-1 CABIN FLOOR PROTECTOR (SHOWN)**  
**D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)**

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

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WITHOUT NOTICE  
WORK ORDER  
NO. 41470

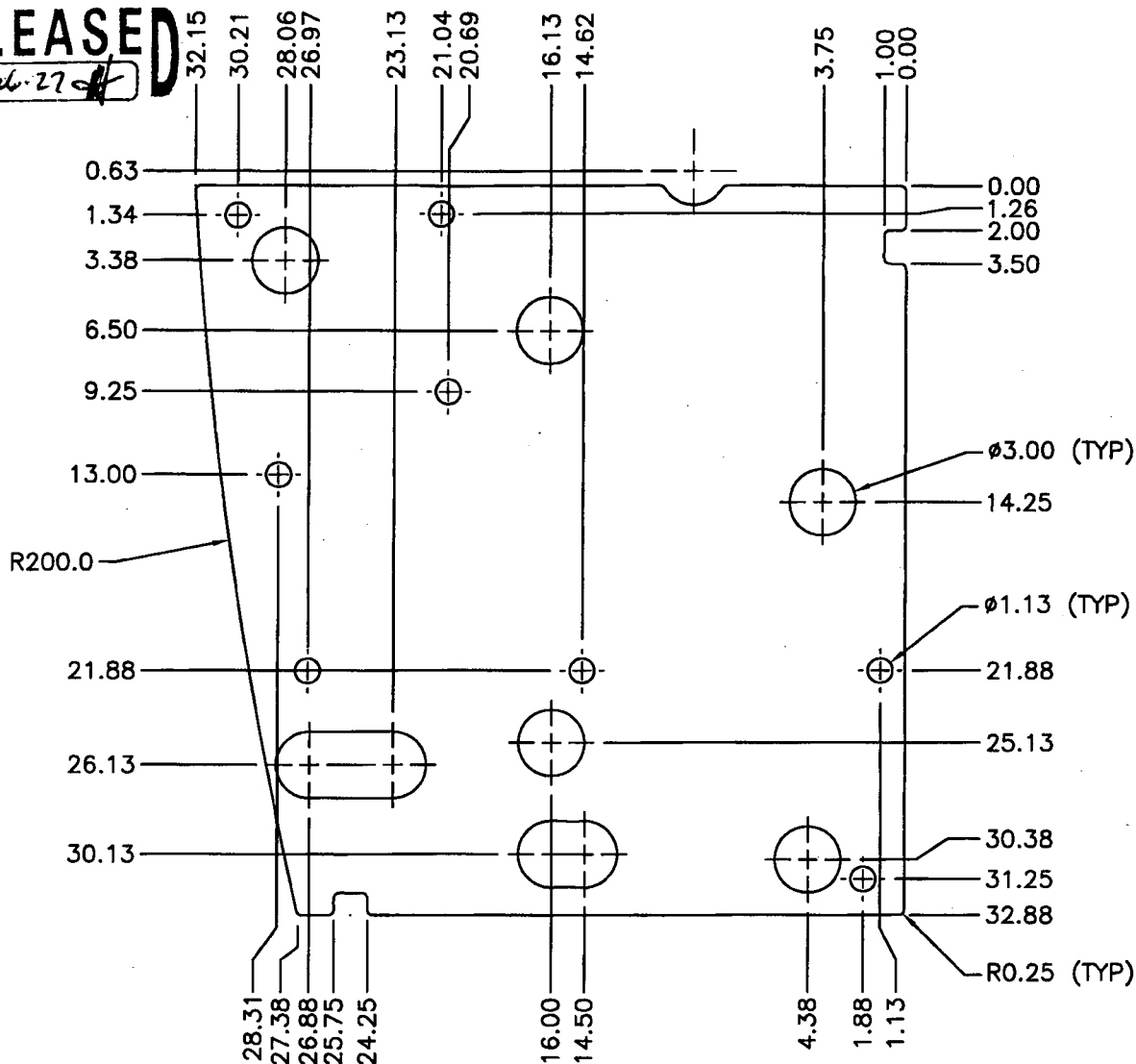
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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3575	REV. A SHEET 2 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8

RELEASED  
07.06.27



**D3575-3 CABIN FLOOR PROTECTOR**

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8967

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WORK ORDER  
NO. 41470

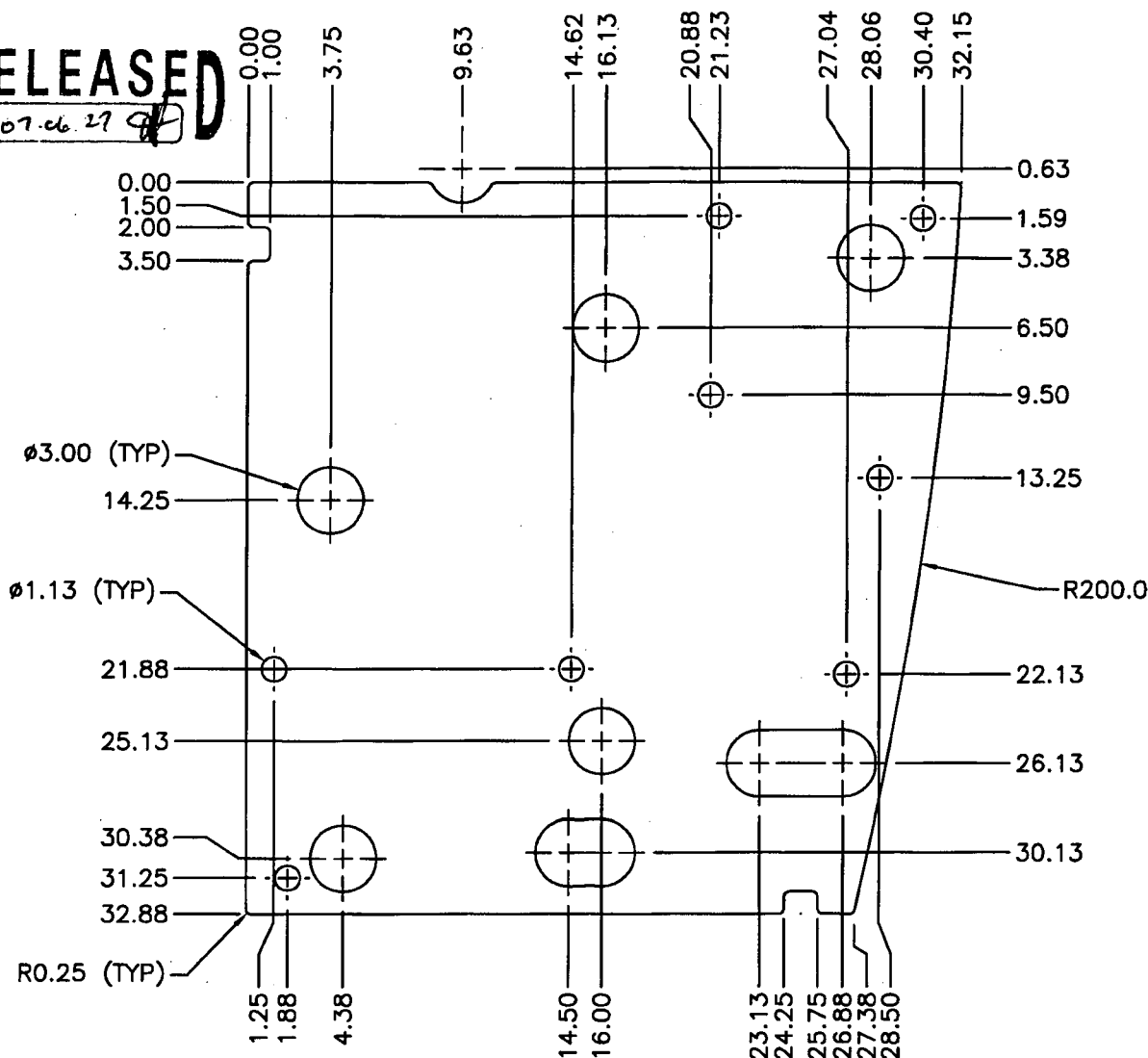
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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3575	REV. A SHEET 3 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8

RELEASED  
07.06.27



**D3575-4 CABIN FLOOR PROTECTOR**

**NOTES:**

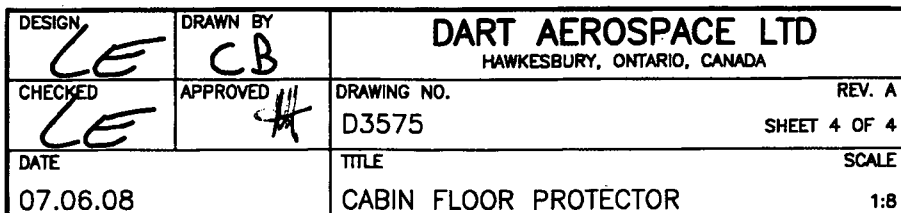
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

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WITHOUT NOTICE  
WORK ORDER  
NO. 4470

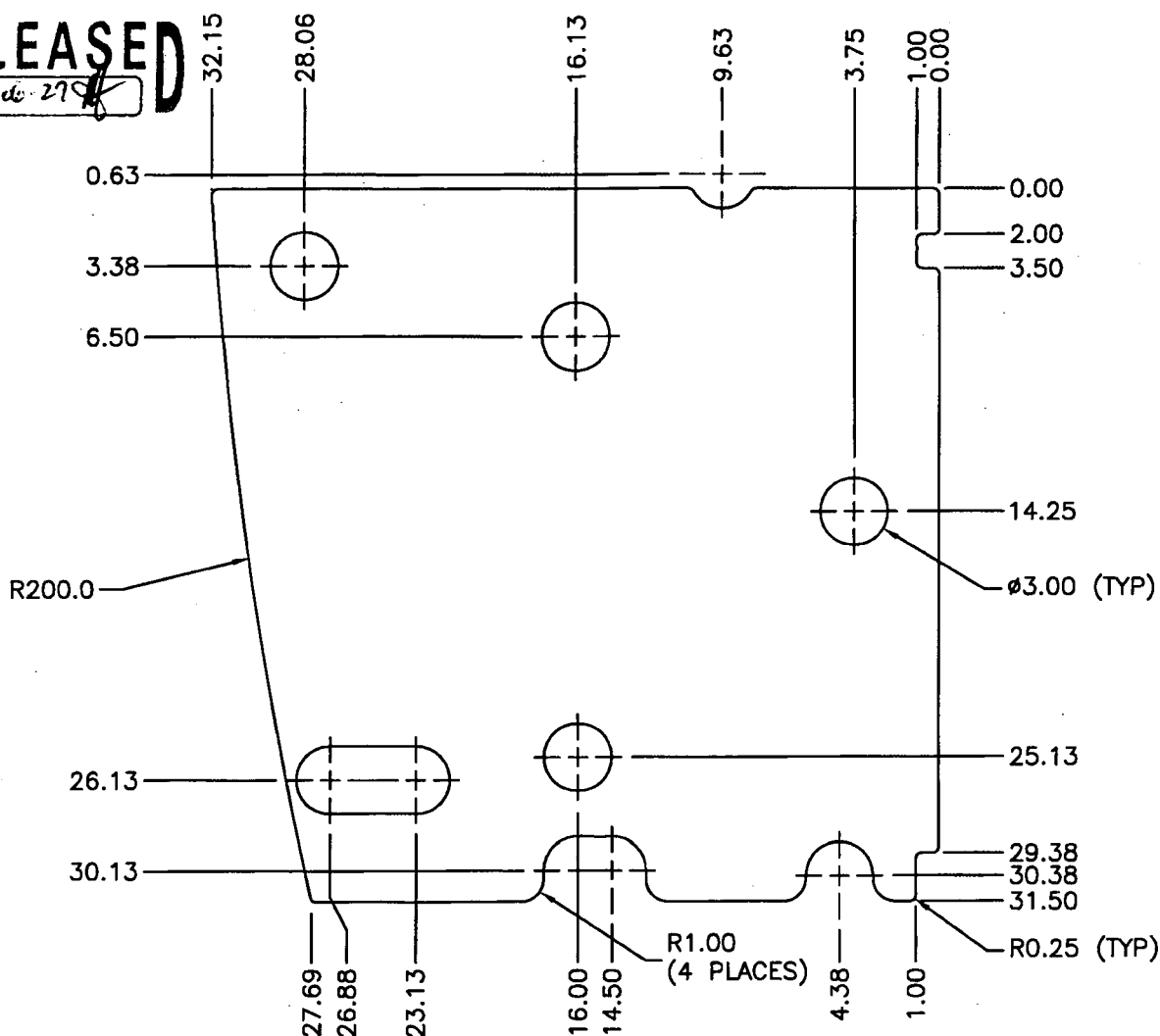
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RELEASED  
07-27-2014



**D3575-5 CABIN FLOOR PROTECTOR (SHOWN)**  
**D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)**

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TOP COPY  
TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04) RETURN TO  
2) FINISH: NONE ENGINEERING  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED UNCONTROLLED  
4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER SUBJECT TO  
ON SMOOTH SIDE OF PART WITHOUT NOTICE  
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED WORK ORDER  
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX NO. 41470  
7) CHECK PER TEMPLATE DT8969

25 THICK COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SHED MARKER  
T INK MARKER  
WITHOUT NOTICE  
WORK ORDER  
NO. 41470

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